

Work Order ID 146473***146473***

Page 1

Wednesday, May 18, 2016 9:12:18 AM

Item ID: D407-797-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 5/2/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MWS

Date:

MAY 19 2016

Tooling:

Date:

QC: _____

Date:

SPC (Y/N): _____

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-797-1	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD407-797-111 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

OCT 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

OCT 21 1962

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, May 18, 2016 9:12:17 AM

Page 1

Work Order ID: 146473

146473

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 5/2/2016

Required Date: 5/18/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.02.09 new issue DD verf:JLM
11.09.12 @ chg 002 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-011		Manufactured	No		58452	110	Each	0.0000	1	2			
D4271-011									**	145600		OCT 20 2016	DAS 28 9-89
Beam Assembly, Fwd													
D4271-013		Manufactured	No		58453	110	Each	1.0000	1	2			
D4271-013									**	145060			DAS 28 9-89
Beam Assembly, Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST453				1					
				141297				1					
D4292-1		Manufactured	No		58530	110	Each	0.0000	2	4			
D4292-1									**	145188		OCT 19 2016	DAS 28 9-89
Fitting													
D4294-1		Manufactured	No			110	Each	3.0000	2	4			
D4294-1									**	144612		OCT 19 2016	DAS 28 9-89
Fitting													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st533				3					
				119386				3					
D4314-1		Manufactured	No			110	Each	26.0000	4	8			
D4314-1									**				DAS 28 9-89
Shim													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				26				OCT 19 2016	DAS 28 9-89
				120515				6					
				123102				20					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 146473

146473

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 5/2/2016

Required Date: 5/18/2016

Start Qty: 2.00

Required Qty: 2.00

D4314-3

Manufactured No

110

Each

43.0000

4

8

D4314-3

Shim

**

OCT 1 9 2016

DAS
628
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST091

43

113351

14

119651

9

123115

20

AN6-17A

Purchased

No

110

Each

18.0000

2

4

AN6-17A

Bolt

**

OCT 1 9 2016

DAS
628
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST334

18

m128403

3

m130466

15

AN6-20A

Purchased

No

110

Each

33.0000

2

4

AN6-20A

BOLT

**

OCT 1 9 2016

DAS
28
9-89
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over005

30

M133932

30

ST334

3

M128936

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. : _____ NCR No. : _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Page 3

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Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 5/2/2016

Required Date: 5/18/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0663J

Purchased

No

110

Each

858.0000

8

16

NAS1149D0663.1

Washer

**

135464 OCT 19 2016

DAS

5

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST263

576

M133134

89

M133769

12

M133812

6

M134634

469

ST269

55

M126334

55

MS21042L6

Purchased

No

110

Each

263.0000

4

8

MS21042L 6

Nut

**

17135008

OCT 19 2016

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST303

263

m133938

6

m134055

7

m134509

100

m134567

50

m134676

100

MS27151-19

Purchased

No

110

Each

67.0000

4

8

MS27151-19

NUT

**

OCT 19 2016

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST275

67

m132285

20

m132399

47

Wednesday, May 18, 2016 9:12:17 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Page 4

Work Order ID: 146473

146473

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 5/2/2016

Required Date: 5/18/2016

Start Qty: 2.00

Required Qty: 2.00

MS24694-10 MS24694-S10 Purchased No

110 Each 7.0000 4 8

MS24694-10

SCREW

DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

7

121166

7

**

OCT 19 2016

DAS
6
9-89
DAS
28
9-89

D4713-1 Manufactured No

110 Each 4.0000 1 2

D4713-1

Spacer

**

OCT 19 2016

DAS
6
9-89
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST121

4

138743

4

MS3367-5-0 Purchased No

110 Each 92.0000 1 2

MS3367-5-0

Tie Wrap

**

OCT 19 2016

DAS
6
9-89
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST272

92

123164

92

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
JAC 3 2016 JAC 3 2016				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

REVIEWER: IS, MI, MU, NSA, AV, 85
USER: AT, ME, SH, MC, CG

This military standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

HEAD MARKING		LENGTH		FED. SUP CLASS					
				5305					
INCREASE OF .001 OVER D DIAMETER FROM THE POINT OF TANGENCY OF R AND THE SHANK WILL BE PERMISSIBLE									
TABLE I									
NOMINAL SIZE		#8	#10	1/4	5/16	3/8	7/16	1/2	9/16
THREADS PER INCH		32UNC-3A	32UNF-3A	26UNF-3A	24UNF-3A	24UNF-3A	20UNF-3A	20UNF-3A	18UNF-3A
D SCREW DIAMETER	MAX MIN	.164 .161	.189 .186	.249 .246	.3115 .3085	.374 .371	.4365 .4325	.499 .495	.5615 .5575
A HEAD DIAMETER	MAX SHARP MIN SHARP ABS MIN	.332 .319 .283	.385 .371 .327	.507 .491 .447	.635 .617 .569	.762 .742 .686	.890 .868 .805	1.017 .992 .919	1.145 1.118 1.036
F FLAT	MAX	.015	.016	.018	.020	.023	.026	.030	.034
H HEAD HEIGHT	REF	.068	.080	.106	.133	.159	.186	.213	.240
M POINT	MAX	.031	.031	.033	.047	.047	.047	.047	.047
R FILLET RADIUS	MAX MIN	.015 .005	.015 .005	.015 .005	.020 .010	.020 .010	.020 .010	.020 .010	.020 .010
TABLE II									
*MINIMUM TENSILE STRENGTH LOAD POUNDS									
NOMINAL SIZE	LOW-ALLOY STEEL	ALUMINUM ALLOY	CORROSION RESISTING STEEL						
Nr. 8-32UNC-3A	1750	870	1190						
Nr. 10-32UNF-3A	2500	1240	1700						
1/4-28UNF-3A	4550	2250	3090						
5/16-24UNF-3A	7250	3600	4930						
3/8-24UNF-3A	10980	5440	7460						
7/16-20UNF-3A	14840	7360	10090						
1/2-20UNF-3A	19990	9910	13590						
9/16-18UNF-3A	25380	12590	17260						
* Based on 125,000 PSI minimum tensile strength for low-alloy steel, 62,000 PSI for aluminum alloy and 85,000 PSI for corrosion resisting steel. Load pounds are calculated by the stress areas indicated in Screw-Thread Standards for Federal Services, Handbook H28.									
MATERIAL: Steel, low-Alloy - Rockwell Hardness C26 to C32; MIL-S-6049 OR MIL-S-6050. Aluminum Alloy - Alloy 2024 of QQ-A-430 or alloy 2024, T4 temper of QQ-A-225. Steel, Corrosion Resisting - Fed. Std. No. 66, steel no. 302, 303, 304, 305 or 315 or equal to or interchangeable with 16-18 or 18-8 chromium nickel alloy steel (developed for cold heading).									
PROTECTIVE COATING OR TREATMENT: Cadmium Plated - QQ-P-416, Type II, Class 3. Anodize - MIL-A-8625, Type I or II. Passivate - QQ-P-35.									
MAGNETIC PERMEABILITY: These fasteners have a magnetic permeability of 2.0 maximum (air-1.0) for a field strength of H-200 oersteds using a magnetic indicator per MIL-I-17214.									
HEAT TREATMENT: For Steel, Low-Alloy - 125,000 PSI to 145,000 PSI tensile strength, MIL-H-6875. For QQ-A-430 Aluminum Alloy - 62,000 PSI tensile strength (min), MIL-H-6088.									
RECESS: The recess shall be in accordance with MS9006.									
THREADS: The threads shall be in accordance with MIL-S-7742.									
ECCENTRICITY: The conical surface of the head shall not be eccentric with the body more than a total runout of .005.									
LENGTH TOLERANCE: Tolerance on the lengths for Nr. 8-32, Nr. 10-32, 1/4-28 and 3/8-24 screws = +1/32, -1/64; for 5/16-24 and 9/16-18 screws = +3/64, -0; for 7/16-20 and 1/2-20 screws = +1/64, -1/32.									
HEAD MARKING: Low-Alloy Steel - One "X" required. Corrosion Resisting Steel - One "-" required. Aluminum Alloy - None required.									
DIMENSIONS: All dimensions are in inches unless otherwise specified.									
PART NUMBER: The MS part number consists of the MS number, plus the coded dash number. See sheet 2 and 3.									
NOTES: (1) For design feature purposes, this standard takes precedence over procurement documents referenced herein. (2) Referenced documents shall be of the issue in effect on date of invitations for bid.									
© FOR CHANGE SEE SHEET I.									
P.A. WC Other Cust 82		TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A		MILITARY STANDARD MS24694					
PROCUREMENT SPECIFICATION MIL-S-7739		SUPERSEDES: AN509		SHEET 1 OF 4					

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 5 AUG 60 REVISED 21 APR 67 6 NOV 68 17 FEB 69

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This military standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

REVISION: 15, MJ, NU, NSA, AV, 85
 USER: AT, ME, SH, MC, CC

FOR REPRODUCTIVE use shall be made from this document.

TABLE III
 DASH NUMBERS AND CODES**

FED. SUP. CLASS
 5305

NOMINAL SIZE		#8-32UNC-3A			#10-32UNF-3A			1/4-28UNF-3A			5/16-24UNF-3A		
LENGTH	GRIP	TOL.	DASH NO.	GRIP	TOL.	DASH NO.	GRIP	TOL.	DASH NO.	GRIP	TOL.	DASH NO.	
9/32	3/32		1	7/64		46							
11/32	3/32		2	7/64		47							
13/32	3/32		3	7/64		48							
15/32	3/32	+1/32	4	7/64	+1/32	49	9/64	+1/32	92	11/64		137	
17/32	3/32	-0	5	7/64	-0	50	9/64	-0	93	11/64		138	
19/32	3/32		6	7/64		51	9/64		94	11/64	+1/32	139	
21/32	7/32		7	7/64		52	9/64		95	11/64	-0	140	
23/32	9/32		8	1/16		53	9/64		96	11/64		141	
25/32	11/32		9	1/16		54	3/16		97	11/64		142	
27/32	13/32		10	5/16		55	1/4		98	11/64		143	
29/32	15/32		11	3/8		56	5/16		99	11/64		144	
31/32	17/32		12	7/16		57	3/8		100	11/64		145	
1-1/32	19/32		13	9/16		58	7/16		101	11/64		146	
1-1/8	21/32		14	5/8		59	1/2		102	11/64		147	
1-1/4	23/32		15	3/4		60	9/16		103	11/64		148	
1-1/2	25/32		16	11/16		61	5/8		104	11/64		149	
1-5/8	27/32		17	3/4		62	11/16		105	11/64		150	
1-3/4	29/32		18	13/16		63	3/4		106	11/64		151	
1-7/8	31/32		19	7/8		64	13/16		107	11/64		152	
2-1/8	1-1/32	+1/64	20	15/16		65	7/8		108	11/64		153	
2-1/4	1-1/32	-1/64	21	1		66	15/16		109	11/64		154	
2-1/2	1-1/32		22	1-1/16		67	1		110	11/64		155	
2-3/4	1-1/32		23	1-1/8		68	1-1/16		111	11/64		156	
2-5/8	1-1/32		24	1-1/4	+1/64	69	1-1/8	+1/64	112	11/64		157	
2-3/2	1-1/32		25	1-5/16	-1/64	70	1-3/16	-1/64	113	11/64		158	
2-1/2	1-1/32		26	1-3/8		71	1-1/4		114	11/64		159	
2-1/2	1-1/32		27	1-7/16		72	1-5/16		115	11/64		160	
2-1/2	1-1/32		28	1-1/2		73	1-3/8		116	11/64	+1/64	161	
2-1/2	1-1/32		29	1-9/16		74	1-7/16		117	11/64	-1/64	162	
2-1/2	1-1/32		30	1-5/8		75	1-1/2		118	11/64		163	
2-1/2	1-1/32		31	1-11/16		76	1-9/16		119	11/64		164	
2-1/2	1-1/32		32	1-3/4		77	1-5/8		120	11/64		165	
2-1/2	1-1/32		33	1-13/16		78	1-11/16		121	11/64		166	
2-1/2	1-1/32		34	1-7/8		79	1-3/4		122	11/64		167	
2-1/2	1-1/32		35	1-15/16		80	1-13/16		123	11/64		168	
2-1/2	1-1/32			2		81	1-7/8		124	11/64		169	
2-1/2	1-1/32			2-1/16		82	1-15/16		125	11/64		170	
2-1/2	1-1/32			2-1/8		83	2		126	11/64		171	
2-1/2	1-1/32			2-3/16		84	2-1/16		127	11/64		172	
2-1/2	1-1/32			2-1/4		85	2-1/8		128	11/64		173	
2-1/2	1-1/32			2-5/16		86	2-3/16		129	11/64		174	
2-1/2	1-1/32			2-3/8		87	2-1/4		130	11/64		175	
2-1/2	1-1/32			2-7/16		88	2-5/16		131	11/64		176	
2-1/2	1-1/32			2-1/2		89	2-3/8		132	11/64		177	
2-1/2	1-1/32			2-9/16		90	2-7/16		133	11/64		178	
							2-1/2		134	11/64		179	
									135	11/64		180	

NOTE: For illustration, material, protective coating and other pertinent data, see sheet 1.

** DASH NUMBER CODE:

- Add "S" before dash number for Cadmium Plated, Low-Alloy Steel Screw.
- Add "A" before dash number for Anodized, Aluminum Alloy Screw.
- Add "C" before dash number for Passivated, Corrosion Resisting Steel Screw.

EXAMPLES OF MS PART NUMBERS:

- MS24694-S1 - #8-32UNC-3A Cadmium Plated, Low-Alloy Steel Screw, 9/32 inch long.
- MS24694-A100 - 1/4-28UNF-3A Anodized, Aluminum Alloy Screw, 27/32 inch long.
- MS24694-C250 - 7/16-20UNF-3A Passivated, Corrosion Resisting Steel Screw, 2-1/32 inches long.

APPROVED 5 AUG 60 REVISED 21 APR 67 6 NOV 68 FOR CHANGE SEE SHEET 1.

P.A. VC	TITLE	MILITARY STANDARD
Other Cust	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°,	MS24694
82	STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A	
PROCUREMENT SPECIFICATION	SUPERSEDES	SHEET
MIL-S-7839	AN509	OF

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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

1.09375

TABLE III (Cont) DASH NUMBERS AND CODES											FED. SUP CLASS 5305	
NOMINAL SIZE	3/8-24UNF-3A			7/16-20UNF-3A			1/2-20UNF-3A			9/16-18UNF-3A		
LENGTH	GRIP	TOL	DASH Nr.	GRIP	TOL	DASH Nr.	GRIP	TOL	DASH Nr.	GRIP	TOL	DASH Nr.
13/32	3/16		181									
15/32	3/16		182	7/32		225	1/4		270			
17/32	3/16		183	7/32		226	1/4		271			
19/32	3/16		184	7/32		227	1/4		272	9/32		330
21/32	3/16		185	7/32		228	1/4		273	9/32		331
23/32	3/16		186	7/32		229	1/4		274	9/32		332
25/32	3/16		187	7/32		230	1/4		275	9/32		333
27/32	3/16		188	7/32		231	1/4		276	9/32		334
29/32	3/16		189	7/32		232	1/4		277	9/32		335
31/32	3/16		190	7/32		233	1/4		278	9/32		336
1-1/32	11/32		191	5/16		234	1/4		279	9/32		337
1-3/32	13/32		192	3/8		235	1/4		280	9/32		338
1-5/32	15/32		193	7/16		236	5/16		281	9/32		339
1-7/32	17/32		194	1/2		237	3/8		282	9/32		340
1-9/32	19/32		195	9/16		238	7/16		283	9/32		341
1-11/32	21/32		196	5/8		239	1/2		284	13/32		342
1-13/32	23/32		197	11/16		240	9/16		285	15/32		343
1-15/32	25/32		198	3/4		241	5/8		286	17/32		344
1-17/32	27/32		199	13/16		242	11/16		287	19/32		345
1-19/32	29/32		200	7/8		243	3/4		288	21/32		346
1-21/32	31/32		201	15/16		244	13/16		289	23/32		347
1-23/32	1-1/32		202	1		245	7/8		290	25/32		348
1-25/32	1-3/32		203	1-1/16		246	15/16		291	27/32		349
1-27/32	1-5/32		204	1-1/8		247	1		292	29/32		350
1-29/32	1-7/32		205	1-3/16		248	1-1/16		293	31/32		351
1-31/32	1-9/32		206	1-1/4		249	1-1/8		294	1-1/32		352
2-1/32	1-11/32		207	1-5/16		250	1-3/16		295	1-3/32		353
2-3/32	1-13/32		208	1-3/8		251	1-1/4		296	1-5/32		354
2-5/32	1-15/32		209	1-7/16		252	1-5/16		297	1-7/32		355
2-7/32	1-17/32		210	1-1/2		253	1-5/8		298	1-9/32		356
2-9/32	1-19/32		211	1-9/16		254	1-7/16		299	1-11/32		357
2-11/32	1-21/32		212	1-5/8		255	1-1/2		300	1-13/32		358
2-13/32	1-23/32		213	1-11/16		256	1-9/16		301	1-15/32		359
2-15/32	1-25/32		214	1-3/4		257	1-5/8		302	1-17/32		360
2-17/32	1-27/32		215	1-13/16		258	1-11/16		303	1-19/32		361
2-19/32	1-29/32		216	1-7/8		259	1-3/4		304	1-21/32		362
2-21/32	1-31/32		217	1-15/16		260	1-13/16		305	1-23/32		363
2-23/32	2-1/32		218	2		261	1-7/8		306	1-25/32		364
2-25/32	2-3/32		219	2-1/16		262	1-15/16		307	1-27/32		365
2-27/32	2-5/32		220	2-1/8		263	2		308	1-29/32		366
2-29/32	2-7/32		221	2-3/16		264	2-1/16		309	1-31/32		367
2-31/32	2-9/32		222	2-1/4		265	2-1/8		310	2-1/32		368
2-33/32	2-11/32		223	2-5/16		266	2-3/16		311	2-3/32		369
2-35/32	2-13/32		224	2-3/8		267	2-1/4		312	2-5/32		370
2-37/32							2-5/16		313	2-7/32		371
2-39/32							2-3/8		314	2-9/32		372
2-41/32							2-7/16		315	2-11/32		373
2-43/32							2-1/2		316	2-13/32		374
2-45/32							2-9/16		317	2-15/32		375
2-47/32							2-5/8		318	2-17/32		376
2-49/32							2-11/16		319	2-19/32		377
2-51/32							2-3/4		320	2-21/32		378
2-53/32							2-13/16		321	2-23/32		379
2-55/32							2-7/8		322	2-25/32		380
2-57/32							2-15/16		323	2-27/32		381
2-59/32							3		324	2-29/32		382
2-61/32							3-1/16		325	2-31/32		383
2-63/32							3-1/8		326	2-33/32		384
2-65/32							3-3/16		327	2-35/32		385
2-67/32							3-1/4		328	2-37/32		386
										2-39/32		387
										2-41/32		388
										2-43/32		389
										2-45/32		390
										2-47/32		391
										2-49/32		392
										2-51/32		393
										2-53/32		394
										2-55/32		395
										2-57/32		396
										2-59/32		397
										2-61/32		398
										2-63/32		399
										2-65/32		400
										2-67/32		401
										2-69/32		402
										2-71/32		403
										2-73/32		404
										2-75/32		405
										2-77/32		406
										2-79/32		407
										2-81/32		408
										2-83/32		409
										2-85/32		410
										2-87/32		411
										2-89/32		412
										2-91/32		413
										2-93/32		414
										2-95/32		415
										2-97/32		416
										2-99/32		417
										2-101/32		418
										2-103/32		419
										2-105/32		420
										2-107/32		421
										2-109/32		422
										2-111/32		423
										2-113/32		424
										2-115/32		425
										2-117/32		426
										2-119/32		427
										2-121/32		428
										2-123/32		429
										2-125/32		430
										2-127/32		431
										2-129/32		432
										2-131/32		433
										2-133/32		434
										2-135/32		435
										2-137/32		436
										2-139/32		437
										2-141/32		438
										2-143/32		439
										2-145/32		440
										2-147/32		441
										2-149/32		442
										2-151/32		443
										2-153/32		444
										2-155/32		445
										2-157/32		446
										2-159/32		447
										2-161/32		448
										2-163/32		449
										2-165/32		450
										2-167/32		451
										2-169/32		452
										2-171/32		453
										2-173/32		454
										2-175/32		455
										2-177/32		456
										2-179/32		457
										2-181/32		458
										2-183/32		459
										2-185/32		460
										2-187/32		461
										2-189/32		462
										2-191/32		463
										2-193/32		464
										2-195/32		465
										2-197/32		466
										2-199/32		467
										2-201/32		468
										2-203/32		469
										2-205/32		470
										2-207/32		471
										2-209/32		472

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REVIEWER: IS, MI, MU, NSA, AV, 85
USER: AT, ME, SH, MC, CO

TABLE IV INTERCHANGEABILITY - (Using Coded Dash Numbers)												REQ. SUP CLASS 5305	
After 23 April 1967 screws given on AN509 are canceled, but their existing stock should be used for maintenance purposes until depleted. USE ONLY THE NEW MS24694 SCREWS FOR NEW DESIGN AND ENGINEERING.													
Codes for canceled and new dash numbers:													
(1) For cadmium plated, carbon steel screws: The following AN509 dash numbers are superseded by the following MS dash numbers with a prefix "S" added. Example: AN509-8R4 superseded by MS24694-S1.													
(2) For anodized, aluminum alloy screws: AN dash numbers with a prefix "DD" superseded by MS dash numbers with a prefix "A". Example: AN509DD8R4 superseded by MS24694-A1.													
(3) For passivated, corrosion resisting steel screws: AN dash numbers with a prefix "C" superseded by MS dash numbers with a prefix "C". Example: AN509C8R4 superseded by MS24694-C1.													
(4) For AN509 part numbers inactive for design after 31 January 1952: Bronze screws, uncoated ("Z" before first dash number) and cadmium plated ("P" before first dash number) are canceled but have no replacement.													
(5) For AN509 part numbers inactive for design after 17 February 1959: Optional design II cross recessed ("H" between first and second dash numbers) and slotted head screws ("L" between first and second dash numbers) are canceled and superseded by the appropriately coded MS dash number. Example: AN509-8R4 or AN509-8-4 superseded by MS24694-S1.													
CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO
8R4	1	10R31	73	516R5	137	616R23	199	716R42	261	816R61	325		
8R5	2	10R32	74	516R6	138	616R24	200	716R43	262	816R62	326		
8R6	3	10R33	75	516R7	139	616R25	201	716R44	263	816R63	327		
8R7	4	10R34	76	516R8	140	616R26	202	716R45	264	816R64	328		
8R8	5	10R35	77	516R9	141	616R27	203	716R46	265	916R7	330		
8R9	6	10R36	78	516R10	142	616R28	204	716R47	266	916R8	331		
8R10	7	10R37	79	516R11	143	616R29	205	716R48	267	916R9	332		
8R11	8	10R38	80	516R12	144	616R30	206	816R6	270	916R10	333		
8R12	9	10R39	81	516R13	145	616R31	207	816R7	271	916R11	334		
8R13	10	10R40	82	516R14	146	616R32	208	816R8	272	916R12	335		
8R14	11	10R41	83	516R15	147	616R33	209	816R9	273	916R13	336		
8R15	12	10R42	84	516R16	148	616R34	210	816R10	274	916R14	337		
8R16	13	10R43	85	516R17	149	616R35	211	816R11	275	916R15	338		
8R17	14	10R44	86	516R18	150	616R36	212	816R12	276	916R16	339		
8R18	15	10R45	87	516R19	151	616R37	213	816R13	277	916R17	340		
8R19	16	10R46	88	516R20	152	616R38	214	816R14	278	916R18	341		
8R20	17	10R47	89	516R21	153	616R39	215	816R15	279	916R19	342		
8R21	18	10R48	90	516R22	154	616R40	216	816R16	280	916R20	343		
8R22	19	416R5	92	516R23	155	616R41	217	816R17	281	916R21	344		
8R23	20	416R6	93	516R24	156	616R42	218	816R18	282	916R22	345		
8R24	21	416R7	94	516R25	157	616R43	219	816R19	283	916R23	346		
8R25	22	416R8	95	516R26	158	616R44	220	816R20	284	916R24	347		
8R26	23	416R9	96	516R27	159	616R45	221	816R21	285	916R25	348		
8R27	24	416R10	97	516R28	160	616R46	222	816R22	286	916R26	349		
8R28	25	416R11	98	516R29	161	616R47	223	816R23	287	916R27	350		
8R29	26	416R12	99	516R30	162	616R48	224	816R24	288	916R28	351		
8R30	27	416R13	100	516R31	163	716R6	225	816R25	289	916R29	352		
8R31	28	416R14	101	516R32	164	716R7	226	816R26	290	916R30	353		
8R32	29	416R15	102	516R33	165	716R8	227	816R27	291	916R31	354		
8R33	30	416R16	103	516R34	166	716R9	228	816R28	292	916R32	355		
8R34	31	416R17	104	516R35	167	716R10	229	816R29	293	916R33	356		
8R35	32	416R18	105	516R36	168	716R11	230	816R30	294	916R34	357		
8R36	33	416R19	106	516R37	169	716R12	231	816R31	295	916R35	358		
8R37	34	416R20	107	516R38	170	716R13	232	816R32	296	916R36	359		
8R38	35	416R21	108	516R39	171	716R14	233	816R33	297	916R37	360		
10R4	46	416R22	109	516R40	172	716R15	234	816R34	298	916R38	361		
10R5	47	416R23	110	516R41	173	716R16	235	816R35	299	916R39	362		
10R6	48	416R24	111	516R42	174	716R17	236	816R36	300	916R40	363		
10R7	49	416R25	112	516R43	175	716R18	237	816R37	301	916R41	364		
10R8	50	416R26	113	516R44	176	716R19	238	816R38	302	916R42	365		
10R9	51	416R27	114	516R45	177	716R20	239	816R39	303	916R43	366		
10R10	52	416R28	115	516R46	178	716R21	240	816R40	304	916R44	367		
10R11	53	416R29	116	516R47	179	716R22	241	816R41	305	916R45	368		
10R12	54	416R30	117	516R48	180	716R23	242	816R42	306	916R46	369		
10R13	55	416R31	118	516R5	181	716R24	243	816R43	307	916R47	370		
10R14	56	416R32	119	616R6	182	716R25	244	816R44	308	916R48	371		
10R15	57	416R33	120	616R7	183	716R26	245	816R45	309	916R49	372		
10R16	58	416R34	121	616R8	184	716R27	246	816R46	310	916R50	373		
10R17	59	416R35	122	616R9	185	716R28	247	816R47	311	916R51	374		
10R18	60	416R36	123	616R10	186	716R29	248	816R48	312	916R52	375		
10R19	61	416R37	124	616R11	187	716R30	249	816R49	313	916R53	376		
10R20	62	416R38	125	616R12	188	716R31	250	816R50	314	916R54	377		
10R21	63	416R39	126	616R13	189	716R32	251	816R51	315	916R55	378		
10R22	64	416R40	127	616R14	190	716R33	252	816R52	316	916R56	379		
10R23	65	416R41	128	616R15	191	716R34	253	816R53	317	916R57	380		
10R24	66	416R42	129	616R16	192	716R35	254	816R54	318	916R58	381		
10R25	67	416R43	130	616R17	193	716R36	255	816R55	319	916R59	382		
10R26	68	416R44	131	616R18	194	716R37	256	816R56	320	916R60	383		
10R27	69	416R45	132	616R19	195	716R38	257	816R57	321	916R61	384		
10R28	70	416R46	133	616R20	196	716R39	258	816R58	322	916R62	385		
10R29	71	416R47	134	616R21	197	716R40	259	816R59	323	916R63	386		
10R30	72	416R48	135	616R22	198	716R41	260	816R60	324	916R64	387		
P.A. WC Other Code 82		TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A						MILITARY STANDARD MS24694					
PROCUREMENT SPECIFICATION NIL-S-7839		SUPERSEDER AN509						SHEET 4 OF					

This military standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 5 AUG 1960 REVISED 21 APR 67 6 NOV 68 FOR CHANGE SEE SHEET 1.

Wednesday, October 19, 2016 3:17:44 PM

146473

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 5/2/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 5/18/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D407-797-1	D	

100	Document Control	SVD	OCT 20 2016		DAS	OCT 20 2016
100	DOCUMENT CONTROL				21	
DC	Memo		0.00		9-89	
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD407-797-111 CHG002					

110	Pick Kit	0.00
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110	
Packaging	Memo 0.00
Packaging	

120	QC4- 100% Inspect kits for completeness	0.00
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120			
QC	Memo	0.06	_____
Quality Control			

5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Qty -111	Part Number	Description
X					D407-797-011	QUICK RELEASE HELI-UTILITY-BASKET
	X				D407-797-012	QUICK RELEASE HELI-UTILITY-BASKET
		X			D407-797-013	QUICK RELEASE HELI-UTILITY-BASKET
			X		D407-797-014	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D407-797-111	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4294-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP

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Revision: D

Date: 15.04.14